

Rev SH

Work Order ID 158812

158812

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Friday, March 31, 2017 7:15:39 PM

Item ID: 647.7611 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lower Deflector
 Start Date: 4/4/2017 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 4/28/2017 Req'd Qty: 4.00 *4* Customer:
 Reference: SCHEDULED

Approvals: Process Plan: _____ Date: MAR 31 2017 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.7600	N/C								

100

0.00

100

BAND SAW

Bandsaw

Memo

0.18

Jeaspa Bandsaw

Cut Blank at 16.800"

4

17-04-15

110

4.62

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

1.65

HAAS CNC vertical machine #1

1-Machine per folio FB406

DWG REV: N/C

FOLIO REV: N/C

2- deburr and break all sharp edges

4

17-04-16

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NS1

NS2

4

4

Reference: SCHEDULED

NR1

NR2

**Insp.
Stamp**

120

0.33

CMM PROG. REV:

0.00

130

0.08

4

Quality Control

DAS
14
9-89

17/04/12

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 4/4/2017 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 4/28/2017 **Req'd Qty:** 4.00 ***1***

Customer:

Reference: SCHEDULED

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140 Outsource process-Anodize per QSI017 4.1.10.1

0.00

140

240.00

Outsource4

Outsource process - Anodize

Memo

Issue P/O to ATG : 36011

1- Black Anodize as per Dwg 647.7600

2- PRIME AS PER DWG, SEE NOTE #7 (**DISREGARD AFTER ASSEMBLY**)

Certification of Comformity is required

4 APR 19 2017

150	Receive & Inspect for Damage & Mat'l Certs	0.00
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150

Packaging

Packaging

Memo

0.08

4x. 80 174 27

Work Order ID 158812
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
155 *155* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo 4.0 mils thickness primer	0.00 0.08				4			DAS 38 9-89 APR 27 2017
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <u>CC/KOSHA</u> Memo ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***	0.00 0.04				4			DAS 6 9-89 APR 28 2017
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.40							17/5/1 2A

DAS
21
9-89

MAY 01 2017

Picklist Print

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Work Order ID: 158812

158812

Parent Item: 647.7611

647 7611

Parent Item Name: Lower Deflector

Start Date: 4/4/2017

Required Date: 4/28/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV: A NEW ISSUE 15/08/05 JFS VERIFIED BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B6.000X1.000		Purchased		No		100	f	7.5706	1.4	5.894737			

M7075T6B6 000X1 000

7075-T6 BAR 6.000" X 1.000"

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	7.5706	
M136103	0.75	
M136344	3.354	
M136899	3.4666	

M137 263

1.405
1.405
2.810
P1704-07
P17-04-15

562

58
96

DART AEROSPACE LTD		Work Order: 158812
Description: Lower Deflector		Part Number: 647.7611
Inspection Dwg: 647.7600 Rev: NC		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125 x 45°	+/-0.010 x +/-0.5°	.120x45	✓		gauge pin Vern	
Ø0.177	+0.005/-0.001	.178			gauge pin	
Ø0.188	+0.005/-0.001	.192				
Ø0.201	+0.005/-0.001	.201				
0.488	+/-0.010	.488			Height gauge	
1.000	+/-0.010	1.001				
5.970	+/-0.010	5.969				
10.433	+/-0.010	10.433				
11.075	+/-0.010	11.074				
11.449	+/-0.010	11.451				
11.569	+/-0.010	11.568				
10.213	+/-0.010	10.214				
7.289	+/-0.010	7.285				
5.985	+/-0.010	5.984				
3.785	+/-0.010	3.785				
1.585	+/-0.010	1.586				
0.375	+/-0.010	.375			Vern LPO	
0.376	+0.002/-0.000	.376			gauge pin	
0.560	+/-0.010	.560			Vern	
0.92	+/-0.010	.096			↓	
R0.250	+/-0.010	.250			Rad gauge	

Measured by: <i>17-04-16</i>	Audited by: <i>DAS 14 9-89</i>	Preliminary Approval:
Date:	Date: 17/04/17	Date:

Rev	Date	Change	Revised by	Approved
A	15.09.09	New Issue	KJ	<i>[Signature]</i>

Jean Francois Sauve

From: Pablo Bravo
Sent: July-31-15 12:56 PM
To: Jean Francois Sauve
Cc: Jean-Luc Menard; Mario Poulin; Jason Gardiner; Alex Quan
Subject: RE: 135 CCK
Attachments: 647.7611.jpg; 647.7612.jpg

JF,

Go with the dimension on the models. It looks like this has to do with the way Solidworks interprets the feature on the drawing. We'll have to make a correction to the drawing file.

Jason/Alex, can you guys add this to the list of drawing changes that need to be implemented?

Thanks,

Pablo

From: Jean Francois Sauve
Sent: Friday, July 31, 2015 4:46 AM
To: Pablo Bravo
Cc: Jean-Luc Menard; Mario Poulin
Subject: FW: 135 CCK

Good morning Pablo,

We would need a response for those 135 deflector as soon as possible since they need to be manufactured 1st thing next week.

Thanks
J.F.

From: Jean Francois Sauve
Sent: July-29-15 11:43 AM
To: Pablo Bravo <pbravo@dartaero.com>
Cc: Jean-Luc Menard <jmenard@dartaero.com>
Subject: 135 CCK

Hi Pablo,

Concerning 647.7811 / .7812 Deflectors. The Chamfer called on the dwg. doesn't reflect the Cad model. Both are at 1/8" x 45 deg. on the Cad model.

Please let me know if I go with the Cad. model or the dwg.

Thanks

JEAN-FRANÇOIS SAUVÉ
Production Engineering Coordinator



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36011

Purchase Order Date 4/19/2017

PO Print Date 4/25/2017

Page Number 1 of 5

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	158812	647.7611 LOWER DEFLECTOR REV. N/C	4/25/2017 Yes 4/25/2017		4.00	\$12.05	\$48.20
FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-PRF-23377 TYPE I CLASS N							
Line Total:							\$48.20
2	158496	647.3912 BREAKAWAY TIP REV. C	5/5/2017 Yes 5/5/2017		6.00	\$11.45	\$68.70
FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-PRF-23377 TYPE I CLASS N							
Line Total:							\$68.70
3	158883	647.3912 BREAKAWAY TIP REV. C	5/5/2017 Yes 5/5/2017		6.00	\$11.45	\$68.70
FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-PRF-23377 TYPE I CLASS N							

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

4/25/2017



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913225

Date: 24-Apr-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
4 ea	Part: 647.7611 Lower Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied) Job: 20955	Rev: N/C Line: 1	80174-27
DATE : 24/04/2017 CERTIFIED SIGNATURE : RECEIVER SIGNATURE : _____ Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. CERTIFICATE OF CONFORMANCE A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS. MADE IN CANADA.			